

Work Order ID 54462

December 09, 2009 1:02:55 PM



Page 1

Item ID: D205-633-021

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli Access Step LH High Gear

Start Date: 12/09/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 12/16/2009 Req'd Qty: 1.00



Customer:

Reference: Return 2009 / RA109115

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: [Signature] Date: 09-12-09 SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

DS19300	Rev B
---------	-------

100	QC5- Inspect part completeness to step on W/O	0.00
-----	---	------



QC

Quality Control

Memo

Original B39859 @ CHG001.
Kit & part complete & in good condition.

0.00

110



Packaging

Packaging

Identify as per dwg & Stock Location: _____ 0.00

Memo

New labels required with the new batch # @ CHG001

0.00

120



QC

Quality Control

QC21- Final Inspection - Work Order Release 0.00

Memo

0.00

DART Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY, ON, CANADA K6A 1K7				TC APPROVAL # 09-89 TEL: 1-613-632-5200	
P/N	D205-633-021	CHG	CHG001		
DESC.	Heli-Access-Step, LH	STC	SH96-57		
LOT	B39859	STC	SR00592/3NY		
MODEL	Bell 205/212/214/412	STC	SR00594NY		
MADE IN CANADA				D2729-1	

09.12.16

12-14

Date: Friday, 13/06/2008 10:47:12 AM
User: Julie Leccocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HELI ACCESS STEP HIGH GEAR LH
Job Number	: 39859	Part Number	: D205633021
Estimate Number	: 12434	Drawing Number	: DSI 9300 REV B
P.O. Number	:	Project Number	: N/A
This Issue	: 13/06/2008 S.O. No. :	Drawing Revision	: B
Prsht Rev.	: NC	Material	:
First Issue	: 1/1 Type : LARGE FAB ASSY	Due Date	: 30/06/2008
Previous Run	: 37063	Qty:	4 Um: Each
Written By	:		
Checked & Approved By	: <u>JUL 08.10.13</u>		
Comment	: Est Rev:B Added D2565-111 05-09-09 KJ/JLM		

REFERENCE ONLY

Additional Product New P/W. Re-packer & I.D.

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

DC

DOCUMENT CONTROL

HJ for JLD 09/02/25

Comment: Photocopy bluefile & type labels per PPPD205-633-021

CHG001

09/02/25

2.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0

D2022101

Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Spacer

Batch: B39880AS 09/02/25 (X)

4.0

D2022103

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Spacer

Batch: B38329AS 09/02/25 (X)

5.0

D2562011

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Strut

Batch: 39882AS 09/02/25 (X)

Date: Friday, 13/06/2008 10:47:12 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP HIGH GEAR LH

Job Number: 39859

Part Number: D205633021

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2563

Step Weldment Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Step Weldment Assembly

Batch: 45162

7.0

D2565101

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Strut

Batch: 41892

8.0

D2565103

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Strut

Batch: 41893

9.0

D2565105

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Strut

Batch: 41894

10.0

D2565107

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Strut

Batch: 41895

11.0

D2565109

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Strut

Batch: 4202

12.0

D2565111

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Strut

Batch: 41896

Date: Friday, 13/06/2008 10:47:12 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP HIGH GEAR LH

Job Number: 39859

Part Number: D205633021

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D3437041

Aft Strut Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Aft Strut Assembly

Batch: 39869

SS 09/02/25 (X4)

14.0

AN45A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: 10906

SS 09/02/25 (X4)

15.0

AN46A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Bolt

Batch: M109545

SS 09/02/25 (X4)

16.0

AN47A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: 108926

SS 09/02/25 (X4)

17.0

AN411A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: 106605

SS 09/02/25 (X4)

18.0

AN414A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: M167534

SS 09/02/25 (X4)

19.0

AN44 7A

EYEBOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

EYEBOLT

Batch: M100446

*****ENSURE THIS IS AN44-7A EYEBOLT*****

SS 09/02/25 (X4)

Date: Friday, 13/06/2008 10:47:12 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP HIGH GEAR LH

Job Number: 39859

Part Number: D205633021

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

AN514A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M106166

SS 09/02/25 (x4)

21.0

AN960JD416

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 64.0000 Each(s)

Washer

Batch: M110523

SS 09/02/25 (x4)

22.0

AN960JD516

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Washer

Batch: M110363

SS 09/02/25 (x4)

23.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Nut

Batch: M109282

SS 09/02/25 (x4)

24.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

Batch: 110362

SS 09/02/25 (x4)

25.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

SS 09/02/25 (x4)

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-633-021

Location:

PPP Rev: A

SS 09/02/25 (x4)

Work Order ID 54462

December 09, 2009 1:02:55 PM

Page 1

Item ID: D205-633-021

Accept

Setup Start

Revision ID:

Stop

Item Name: Heli Access Step LH High Gear

Start Date: 12/09/2009 Start Qty: 1.00

Cust Item ID:

Required Date: 12/16/2009 Req'd Qty: 1.00

Customer:

Reference: Return 2009 / RA109115

Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date: 09-12-09

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

DS19300

Rev B

100

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Original B39859 @ CHG001.

Kit & part complete & in good condition.

110

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

New labels required with the new batch # @ CHG001

C209112/10

120

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control